

Work Order ID 57565

Thursday, April 08, 2010 10:41:37 AM



Page 1

Item ID:	D4030-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Assembly (350)					
Start Date:	4/14/2010	Start Qty:	1.00			
Required Date:	4/21/2010	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	<u>mf</u>	Date:	<u>10-4-8</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4030	A								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110	Assemble as per dwg	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

10/4/25 ①

SB 10/04/30 ①

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4030-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Long Basket Assembly (350)

Start Date: 4/14/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 4/21/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PDP 58064

0.00

Packaging

6/10/4/30

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/30

ME
10-4-30

W/O:		WORK ORDER CHANGES					
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Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Date: 4/14/2010

Required Date: 4/21/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN310C4  Nut		Purchased	No			100	Each	92.0000	3.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST349

92

114306

92

D3913-041

Manufactured

No

100

Each

0.0000

1.0000

Long Basket Base Assembly, 350

D3914-041

Manufactured

No

100

Each

0.0000

1.0000

Long Basket Lid Assembly (350)

D2530

Manufactured

No

100

Each

9.0000

1.0000

Handle Weldment

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST508

9

56058

9

M114306

B57566 SD 10/4/30

B57093 SD 10/4/30

57736 Camp

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D2535  Spring		Manufactured	No			100	Each	33.0000	2.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST504

33

56355

33

56355

D2537



Bushing

Manufactured No

100

Each

33.0000

4.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST504

33

53181

33

53181

D3917-3



Washer

Manufactured No

100

Each

24.0000

6.0000



Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST096

24

57144

24

57144

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Required Qty: 1.00

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D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	9.0000	2.0000 			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST101

9

53757

9

D3953-7



Spring Spacer

Manufactured

No

100

Each

23.0000

2.0000


53757





Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST101

23

53970

23

D3953-9



Gas Spring Washer

Manufactured

No

100

Each

38.0000

2.0000


53970





Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST101

38

53642

38

53642

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3953-17  Gas Spring Spacer		Manufactured	No			100	Each	16.0000	2.0000 			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST101

16

57143

16

D3953-19

Gas Spring Bracket

Manufactured No

100

Each

0.0000

1.0000


57143

57607



D3953-21

Gas Spring Bracket

Manufactured No

100

Each

26.0000

1.0000




Warehouse Loc Qty Loc Code

Location

Main Warehouse

ENG

7

56407

7

Main Warehouse

ST102

19

57145

19

56407

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Shop Packet Print

Page 4

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3969-3 Manufactured No



Spring (Basket Lid)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ENG

7

55716

7

AN3-14A

Purchased

No

100

Each

28.0000

4.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST351

28

109754

28

AN3-16A

Purchased

No

100

Each

71.0000

2.0000



Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST352

71

111965

21

113845

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 4/21/2010

Start Qty: 1.00

Required Qty: 1.00

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AN310-4  NUT		Purchased	No			100	Each	28.0000	3.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST314

28

113845

28

AN4-12



Bolt

Purchased

No

100

Each

65.0000

3.0000

113845



10/4/29

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST357

65

104016

15

114292

50

104016

Thursday, April 08, 2010 10:41:37 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D4030-041



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Start Date: 4/14/2010

Required Date: 4/21/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN5-17A 		Purchased	No			100	Each	115.0000	4.0000			
Bolt												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST323 100

114324 100

114324

Main Warehouse

ST339 15

113538 15

MS21042L3

Purchased

No

100

Each

1,331.000

6.0000



Nut

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST300 1331

113537 347

113644 984

113644

Thursday, April 08, 2010 10:41:37 AM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 4/21/2010

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L5  Nut		Purchased	No			100	Each	377.0000	4.0000	✓		

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST300

377

113523

26

113537

151

114108

200

MS24665-151

Purchased

No

100

Each

719.0000

3.0000



Cotter Pin

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST309

719

17566

719

MS24665-300

Purchased

No

100

Each

100.0000

2.0000



Cotter Pin

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST309

100

105279

2

110123

98

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149C0432R Purchased

No

100

Each

194.0000

2.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST297

194

114292

194

NAS1149F0332P Purchased

No

100

Each

1,031.0000

8.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

1031

18057

1031

NAS1149F0432P Purchased

No

100

Each

276.0000

6.0000



Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST275

276

110098

173

112940

97

18057

6

Thursday, April 08, 2010 10:41:37 AM

Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NAS1149F0563P  Washer		Purchased	No			100	Each	88.0000	4.0000 ✓			

EC 4/14/29

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST275	88	
108471	88	

108471

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

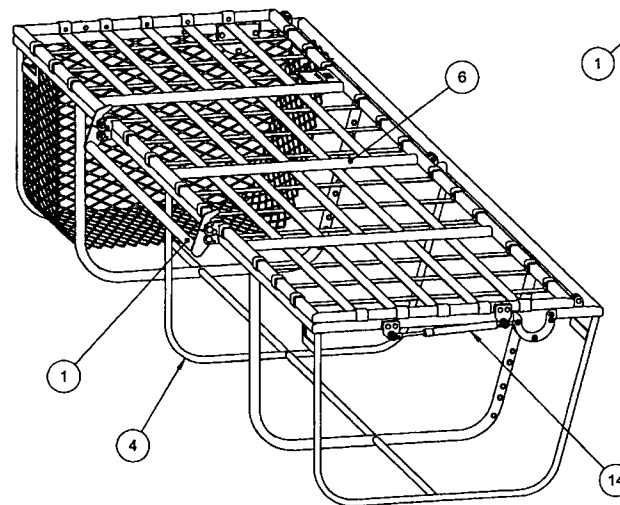
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

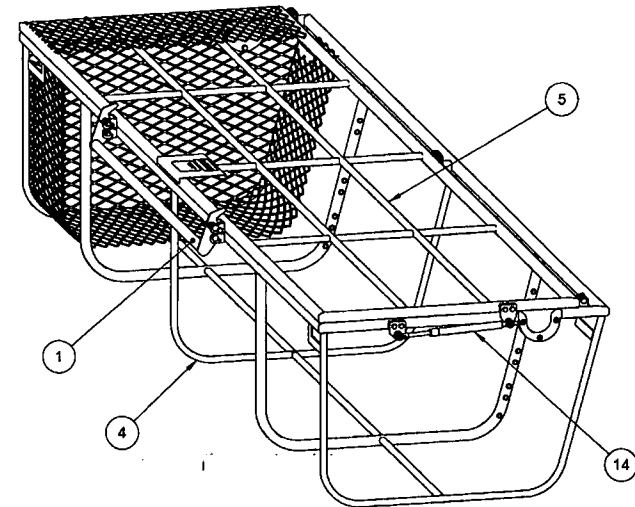
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-19A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	8	8	NAS1149F0332P	WASHER
28	2	2	NAS1149C0432R	WASHER
29	6	6	NAS1149F0432P	WASHER
30	4	4	NAS1149F0563P	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
2010-03-22
nm

57565

A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED		D4030	SHEET 1 OF 3
MFG. APPR.		TITLE	SCALE
APPROVED		LONG BASKET ASSY (350)	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.16		

Dart Aerospace Ltd

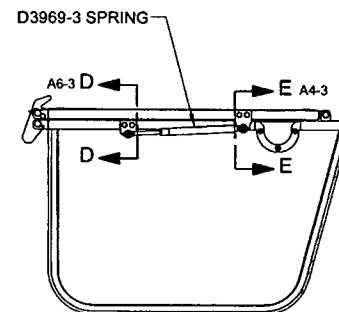
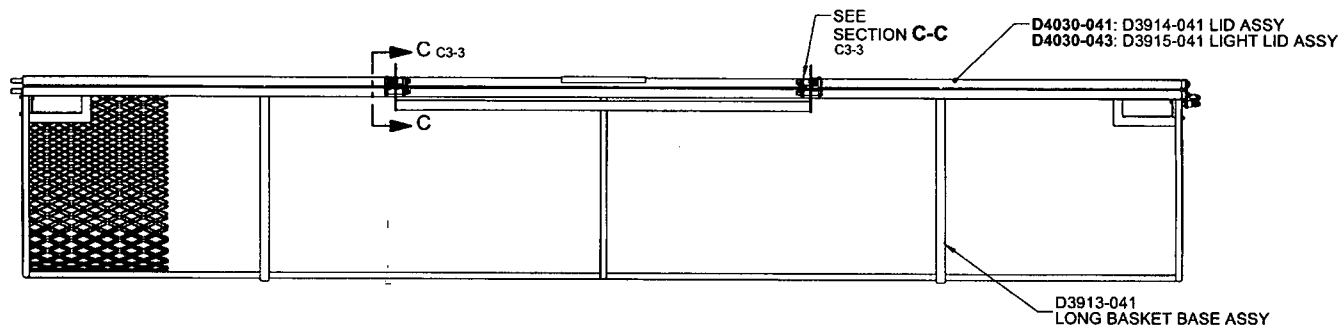
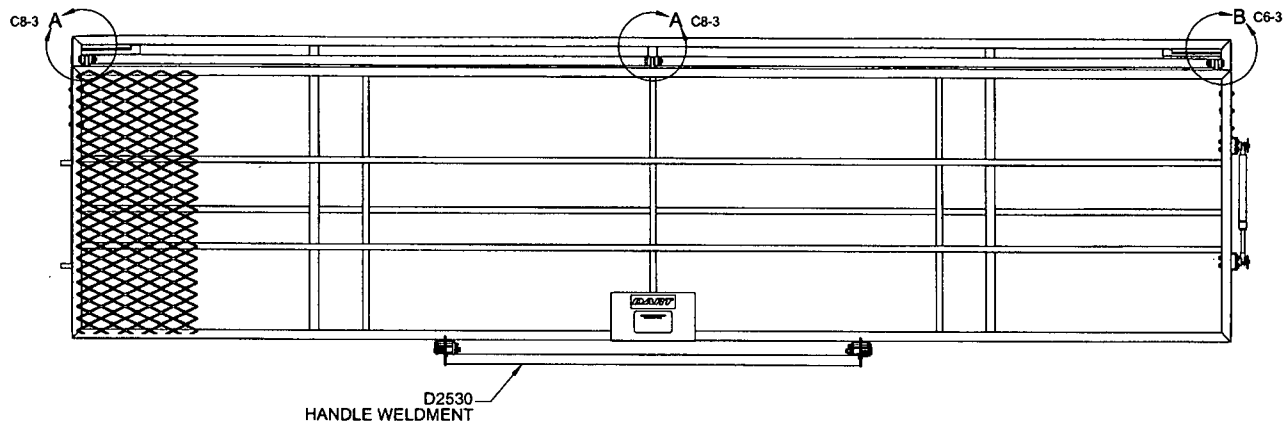
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D4030-041 LONG BASKET ASSY (350) (SHOWN)
(MESH SHOWN LOCALLY OR REMOVED FOR CLARITY)

D4030-043 SHORT BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)

57565

RELEASED
2010-03-22

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JFH		
CHECKED		DRAWING NO. D4030	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE LONG BASKET ASSY (350)	SCALE
DE APPR.			NTS
DATE	10.03.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

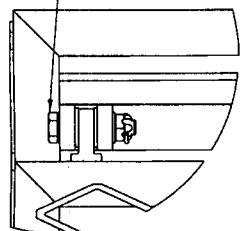
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

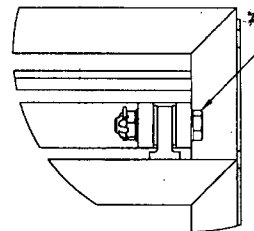
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

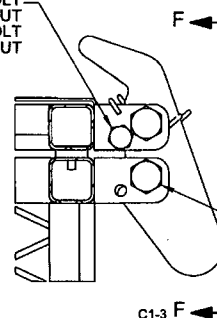


DETAIL A D8-2
D5-2



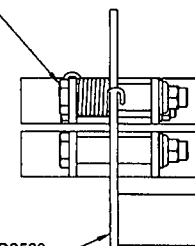
DETAIL B D3-2

D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT
D4030-043: AN5-19A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL





D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-03-22
JWP

57565

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4030	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries